€ate:

Monday, 02/02/2009 11:49:49 AM

User: Julie Dawson

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 45384 : 11168

**Estimate Number** P.O. Number

This Issue

: 02/02/2009

Prsht Rev. : NC

: // : 44443 Type

S.O. No. :

**Part Number** 

**Drawing Name** 

: D22823

: TUBE

**Drawing Number** 

: D2282 REV E

Project Number

: N/A : E

**Drawing Revision** 

Material

**Due Date** 

: 28/02/2009

Qty:

80 Um:

Each

Checked & Approved By

Comment

Written By

First Issue

**Previous Run** 

: Est Rev:A

Removed from 9 Digit

: MACHINED PARTS

05-12-02 JLM

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M304TR0675W091

304 RD Tube .675 x .091W



Comment: Qty.:

Total: 16.6236 f(s)

Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness

(M304TR0.675W.091)

Batch <u>M//0590</u>

2.0

HARDINGE



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Dwg D2282 and Folio FA188

2-Deburr

QC2



3.0

Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1

**PACKAGING RESOURCE #1** 







Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Dart Aerospace	Ltd
----------------	-----

W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE By Date			Date Qty		Approval Chief Eng / Prod Mgr	Approval QC Inspector			
					NCR: Yes No DQA:							
	R	esolution:							Date: _			
NCR:	1		WORK ORL	ORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP Description of NC Section A		Initial Action Descrip Chief Eng Chief Eng		Section B on Sign & Date				Approval Chief Eng	Approval QC Inspector		
						·			4			
NOTE: Da	ate & initia	al all entries								•		

Date:

Monday, 02/02/2009 11:49:49 AM

User: Julie Dawson

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: TUBE** 

Job Number: 45384

Part Number: D22823

Job Number:

Seq. #:

**Machine Or Operation:** 

Description:

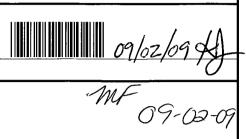
6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



Dart Aerosp	oace I	Ltd
-------------	--------	-----

W/O:			WORK ORDER CHANGES								
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto		
							_				
Part No	:	PAR #:	Fault Category:	NCR:	Yes N	lo DC	A:	Date: _			
	Resolution:		Disposition:	QA: N	C Clo	sed:		Date: _			
NCR:	CR: WORK ORDER NON-CONFORMANCE (NCR)								· · · · · · · · · · · · · · · · · · ·		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification		Annroyal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto		
				N .						

DART AEROSPACE LTD	Work Order: NS384	
Description: Handle Tube	Part Number: D2282-3	
Inspection Dwg: D2282 Rev: E	Page 1 of	1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.375	+0.000/-0.020	2.370				
			, .			
·						
				-		
٠,						
					~~~~~.	
			,			
				_		

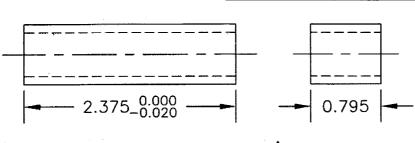
Measured by:	Audited by:	81	Prototype Approval:	N/A
Date: 0 9/02/6/6	Date:	09/02/06	Date:	N/A

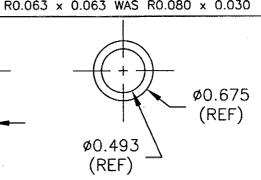
Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue P/O D350-615-041	KJ/RF	
В	05.04.19	Tolerance changed	KJ/JLM ,	
С	06.03.15	Dwg Rev update	KJ/JLM	
				<del></del> _

	•													
W/O:	WORK ORDER CHANGES						WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
			·						. <u></u>					
Part No: PAR #: _		PAR #:	Fault Category: NCI				NCR: Yes No DQA: Date:							
Resolution:			Disposition	QA: N/	QA: N/C Closed: Date:									
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (N	ICR)		,						
DATE	STEP	Description of NC		tion B	Verification		Approval	Approval						
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	S	gn & Date	Section C		Chief Eng	QC Inspector				
<i>e</i>														

	•	
DA	<i>F</i> 37	4

DESIG	BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECK	(ED .: O	APPROVED_	DRAWING NO. REV. E
	w	1000	D2282 SHEET 1 OF 2
DATE			TITLE SCALE
05.0	06.07		HANDLE TUBES 1:1
Α		94.10.14	NEW ISSUE
В		95.03.23	RE-DESIGN
С		97.10.20	CORRECTED NUMBERING SCHEME
D		05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
E		05.06.07	D2282-5 304 SS WAS 303 SS;



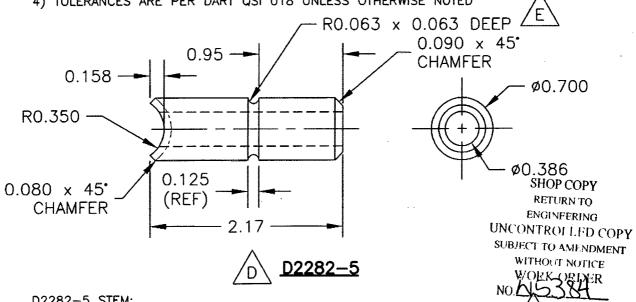


D2282-3

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1994 by DART AEROSPACE LTD

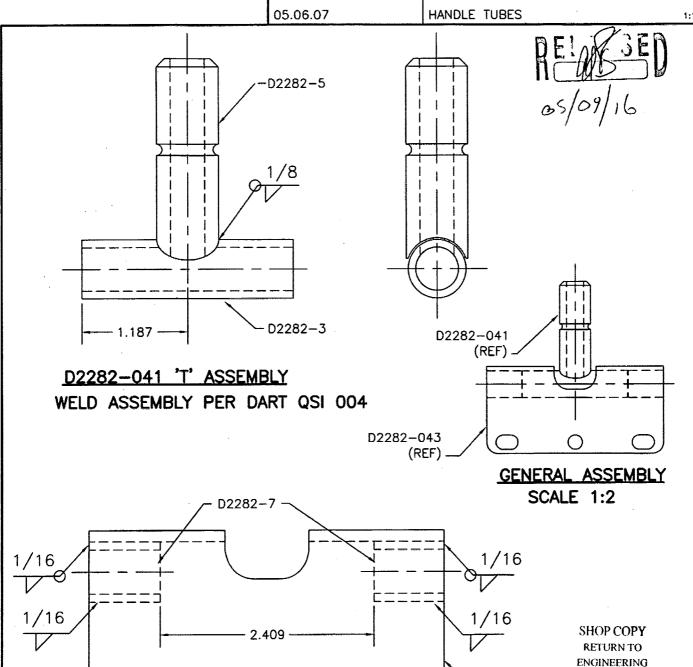
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

## **Dart Aerospace Ltd**

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE			ı	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									,	
Part No.	•	DAD #-	Foult Cot		NCD.	Vas N	- DO	• -	<b>D</b>	
Part No: PAR #:				_ Fault Category: NC _ Disposition: QA						
		T							Date:	
NCR:	T		WORK ORL	PER NON-CONFORM	ANCE (	NCH)				
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Action Description			Sign &	Verification		Approval	Approval
			Chief Eng	Chief Eng		Date	Section C		Chief Eng	QC Inspector
								<del>,</del> ,		



DESIGN BW	DRAWN BY		ROSPACE LTD (, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. E
u'	1 1115	D2282	SHEET 2 OF 2
DATE		TITLE	SCALE
05.06.07		HANDLE TUBES	1:1



D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004

D2281

UNCONTROLLED COPY

**SUBJECT TO AMENDMENT** WITHOUT NOTICE

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart	<b>Aeros</b>	pace	Ltd
------	--------------	------	-----

W/O:			WO	RK ORDER CHANG	ES				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
Resolution:		solution:	Disposition:		QA: N/C Closed:			Date:	
NCR:		•	WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	CTED	Description of NC	Corrective Action Section		on B	Verific	Verification	A	Annuarial
DATE	SIEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	&   Secti		Approval Chief Eng	Approval QC Inspector
									;
			1		1			l	1